

## PATENT ABSTRACTS OF JAPAN

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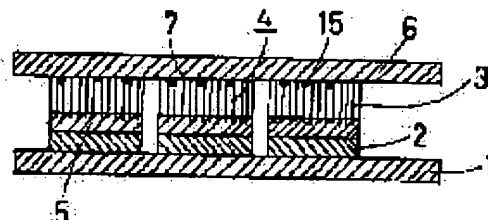
(72)Inventor : OTOMINE KAZUO

## (54) HEAT TRANSFER TYPE APPLIQUE AND MANUFACTURE THEREOF

## (57)Abstract:

PURPOSE: To transfer a mark with a desired shape and color at a desired location by a method wherein a pattern state heat-sensitive adhesive layer is temporarily fixed on a mold releasable base material, and a pattern state bonding layer is provided on the top of it, and a flocked layer is formed on the bonding layer, and a fine member for decoration is provided on the top of it, and an adhesive tape for masking is pasted on the upper end surface.

CONSTITUTION: A pattern state heat-sensitive adhesive layer 2 is temporarily fixed on a mold releasable base material 1 made of a paper on which a mold releasable process is applied or a synthetic resin film, etc. On the upper surface of the adhesive layer 2, a pattern state bonding layer 5 with powerful adhesion and stretchability is provided. A short fiber 3 such as cotton, rayon, nylon, acrylic, polyester, etc., is flocked on the bonding layer 5 to form a flocked layer 4 with a pattern. A fine member for decoration 15 such as a metal powder, foil pieces, synthetic resin particles, colored glass, etc., is provided on the top of the flocked layer 4 by an adhesive. In addition, an adhesive tape for masking 6, of which adhesion is totally lost when the temperature ascends by heating, is pasted on the upper end surface 7 of the flocked layer 4 on which the fine member for decoration 15 has been provided.



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## EFFECT OF THE INVENTION

[Function and Effect of the Invention] The pattern-like sensible-heat type adhesives layer 2 is installed tentatively to the mold-release characteristic base materials 1, such as paper which this invention is the above composition and performed mold-release characteristic processing, or a synthetic-resin film. The pattern-like glue line 5 which has powerful adhesive strength and powerful elasticity is formed in the upper surface of this pattern-like sensible-heat type adhesives layer 2. Furthermore, the staple fibers 3, such as a rayon nylon system, acrylic, and a polyester system, are formed in the pattern-like glue line 5. Adhesives are minded [ of the hair transplantation layer 4 ]. Furthermore, a metal powder, the piece of a foil, a synthetic-resin particle, The detailed members 15 for an ornament, such as colored glass, are formed. Moreover, when adhesiveness made the completely lost adhesive tape 6 for masking stick on the upper end-face section 7 of the hair transplantation layer 4 which formed the detailed member 15 for an ornament of a pattern pattern and formed the hot printing formula applique 10 further at the time of the temperature rise by heating It exfoliates from the pattern-like sensible-heat type adhesives layer 2. transferred -- at the time of the imprint to a member 12, as the mold-release characteristic base material 1 was illustrated to drawing 8 and drawing 19 It flows into the organization of a member 12. next, the pattern-like sensible-heat type adhesives layer 2 -- transferred -- the hot melt adhesive which dissolved when heated at the temperature (about 120degreeC) which the hot melt adhesive which hit against the processed field 14 of a member 12, and was contained in the pattern-like sensible-heat type adhesives layer 2 with heaters, such as an iron, dissolves -- transferred -- On the other hand, the adhesive tape 6 for masking can carry out ablation removal of the adhesive tape 6 for masking easily, as it illustrated to drawing 10 and drawing 21 , since adhesiveness was completely lost in the time of the temperature rise by heating (about 120degreeC). While cooling after that, the hot melt adhesive which flowed will be in an adhesion state firmly.

[0031] therefore, transferred -- a pattern that the beautiful detailed member 15 for an ornament was formed in the member 12 is formed

[0032] Moreover, a pattern [ that it had irregularity ] handle 13 can be acquired by differing in the length of the staple fiber 3 which forms the hair transplantation layer 4.

[0033] Moreover, coloring agents, such as a pigment and a color, can be applied all over a part of hair transplantation layer 4 of a pattern pattern, it can have coloring fiber, and a desired pattern can be performed simply and quickly certainly by having formed a pattern [ that the detailed member 15 for an ornament was formed further ] hair transplantation layer 9.

[0034] By the mold-release characteristic base material 1, the hair transplantation layer 4 is pinched, the hair transplantation layer 4 which does not continue and deteriorate at a long period of time can be obtained at the time of storage, and it can form the beautiful encaustic handle 13 again at the time of an imprint while sticking the adhesive tape 6 for masking whose adhesiveness is completely lost at the time of the temperature rise by heating on the upper end-face section 7 which formed the detailed member 15 for an ornament of the hair transplantation layer 4 or the encaustic hair transplantation layer 9.

[0035] furthermore, the imprint to a transferred member which has elasticity -- being easy -- transferred -- on the occasion of expansion and contraction of a member, the crevice between staple fibers 3 is

suitably adjusted by the pattern-like glue line 5, defluxion of a staple fiber 3 is prevented, and encaustic handles, such as a three-dimensional and beautiful pattern or a character, can be acquired

[0036] Moreover, by having considered as the bilayer of the pattern-like sensible-heat type adhesives layer 2 and the pattern-like glue line 5, adhesion to a transferred member and defluxion of the hair transplantation layer 4 are ensured, it continues and the encaustic handle 13 after an imprint can be saved at a long period of time.

[0037] Moreover, conventionally, although removal cleaning of the excessive powder or excessive pellet-like hot melt adhesive for being sprinkled by hair transplantation portions other than the pattern pattern which powder or pellet-like hot melt adhesive needs in a processing process must be carried out, it is not necessary to perform a complicated means like the conventional process on the occasion of formation of the pattern-like sensible-heat type glue line 5, and the pattern-like sensible-heat type glue line 5 is formed at an easy process.

[0038] moreover, while structure is very easier still, and it is suitable for mass production method and being able to provide cheaply, a women child can imprint by easy operation using an iron -- etc. -- many industrial effects are done so

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 TECHNICAL PROBLEM
 

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[Problem(s) to be Solved by the Invention] By the way, for the heat reversal formula hair transplantation imprint ground illustrated to drawing 22, a fault not desirable on a feeling of beauty since the length of the staple fiber 22 installed tentatively through the temporary glue line 21 to the mother ground 20 for ablation cannot be lengthened since it is reversed and hot printing is carried out, and the length of a staple fiber 22 must be arranged further identically and a concavo-convex change cannot be given to the hair transplantation layer 23 is \*\*\*\*\*.

[0005] Moreover, the useless process for removing the powdered hot-melt resin 36 which adhered to the staple fiber 33 by the method of construction of the hot printing hair transplantation applique illustrated to drawing 23 or drawing 28 is needed. If the hot-melt resin 36 keeps remained in a staple fiber 33 Remain, while there is a possibility of worsening a hand, without imprinting a staple fiber in three dimensions and the adhesives or the thermofusion nature resin which is the film layer 5 of the laminating sheet B had adhered at the nose of cam of a staple fiber, and a feeling of beauty is worsened. \*\*\*\* -- after exfoliating the detachability base material 1, by making the particle of the hot-melt resin 36 adhere to the adhesives layer 32, the means for making the hot-melt resin 36 adhere was required for the adhesives layer 32, and fear, like the staple fiber 33 installed tentatively in the film layer 5 causes a position gap was

[0006] This invention can solve the above-mentioned trouble and can imprint it accurately quickly in the position of a request of a mark with a desired configuration and desired color. Furthermore, adhesion of a binder does not arise at all at the nose of cam of a hair transplantation layer, but a beautiful pattern can be acquired. And the handle of a complicated form can also be processed satisfactory and the jump pattern separated with the handle can also be imprinted with pattern composition. \*\*\*\* -- the charge of work timber also has convenient use -- there is no loss like the conventional technology only in a required pattern encaustic portion -- and it aims to let manufacture offer easy hot printing formula applique and its manufacturing method for it

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## DETAILED DESCRIPTION

[Detailed Description of the Invention]

[0001]

[Industrial Application] this invention -- manufacture -- while it is easy, it is related with the hot printing formula applique which can ensure an imprint to a desired position, and its manufacturing method

[0002]

[Description of the Prior Art] As conventionally illustrated to drawing 22, the temporary glue line 21 is formed in the mother ground 20 for ablation by the heat reversal formula hair transplantation imprint ground. Carry out hair transplantation tentative installation highly, and the hair transplantation layer 23 is formed. next, the staple fiber 22 -- the temporary glue line 21 -- density -- Furthermore, the encaustic pattern-like glue line 24 is formed with powerful adhesives on the hair transplantation layer 23, and what next fixed the hot-melt resin layer 25 on the encaustic pattern-like glue line 24 is known (refer to JP,53-35619,B).

[0003] Moreover, as illustrated to drawing 23 or drawing 28 by the method of construction of hot printing hair transplantation applique, the adhesives layer 32 of a desired pattern is formed in the detachability base material 31. On this adhesives layer 32, transplant hair in a staple fiber 33 and the hair transplantation sheet A is manufactured. So that the laminating sheet B which carried out the laminating of the film layer 35 which becomes the base material 34 for an imprint from the weak adhesives or the thermofusion nature resin of adhesive strength independently may be prepared and the staple fiber 33 of the hair transplantation sheet A may next touch the film layer 35 of the laminating sheet B in the laminating sheet B Pile up the hair transplantation sheet A, make the film layer 35 install a staple fiber 33 tentatively, and, subsequently the detachability base material 31 is torn off from the adhesives layer 32. Make the front face of the exposed adhesives layer 32 fix the powdered hot-melt resin 36, and the imprint sheet C is manufactured. Place and carry out heating pressurization, the hot-melt resin 36 is made to weld to the transferred object 37 so that the hot-melt resin 36 may touch the field of a request of this imprint sheet C of the transferred object 37, and what tore off the base material 34 for an imprint is known (refer to JP,2-24239,B).

[0004]

[Problem(s) to be Solved by the Invention] By the way, for the heat reversal formula hair transplantation imprint ground illustrated to drawing 22, a fault not desirable on a feeling of beauty since the length of the staple fiber 22 installed tentatively through the temporary glue line 21 to the mother ground 20 for ablation cannot be lengthened since it is reversed and hot printing is carried out, and the length of a staple fiber 22 must be arranged further identically and a concavo-convex change cannot be given to the hair transplantation layer 23 is \*\*\*\*\*.

[0005] Moreover, the useless process for removing the powdered hot-melt resin 36 which adhered to the staple fiber 33 by the method of construction of the hot printing hair transplantation applique illustrated to drawing 23 or drawing 28 is needed. If the hot-melt resin 36 keeps remained in a staple fiber 33 Remain, while there is a possibility of worsening a hand, without imprinting a staple fiber in three dimensions and the adhesives or the thermofusion nature resin which is the film layer 5 of the

laminating sheet B had adhered at the nose of cam of a staple fiber, and a feeling of beauty is worsened. \*\*\*\* -- after exfoliating the detachability base material 1, by making the particle of the hot-melt resin 36 adhere to the adhesives layer 32, the means for making the hot-melt resin 36 adhere was required for the adhesives layer 32, and fear, like the staple fiber 33 installed tentatively in the film layer 5 causes a position gap was

[0006] This invention can solve the above-mentioned trouble and can imprint it accurately quickly in the position of a request of a mark with a desired configuration and desired color. Furthermore, adhesion of a binder does not arise at all at the nose of cam of a hair transplantation layer, but a beautiful pattern can be acquired. And the handle of a complicated form can also be processed satisfactory and the jump pattern separated with the handle can also be imprinted with pattern composition. \*\*\*\* -- the charge of work timber also has convenient use -- there is no loss like the conventional technology only in a required pattern encaustic portion -- and it aims to let manufacture offer easy hot printing formula applique and its manufacturing method for it

[0007]

[Means for Solving the Problem] The hot printing formula applique of this invention for attaining the above-mentioned purpose installs tentatively the pattern-like sensible-heat type adhesives layer 2 to the mold-release characteristic base materials 1, such as paper which performed mold-release characteristic processing, or a synthetic-resin film. The pattern-like glue line 5 which has powerful adhesive strength and powerful elasticity is formed in the upper surface of this pattern-like sensible-heat type adhesives layer 2. Furthermore, carry out hair transplantation fixing of the staple fibers 3, such as cotton, a rayon nylon system, acrylic, and a polyester system, and the hair transplantation layer 4 of a pattern pattern is formed in the pattern-like glue line 5. Adhesives are minded [ of the hair transplantation layer 4 ]. Furthermore, a metal powder, the piece of a foil, a synthetic-resin particle, [ whether the adhesive tape 6 for masking whose adhesiveness forms the detailed members 15 for an ornament, such as colored glass, and is completely further lost at the time of the temperature rise by heating is made to stick on the upper end-face section 7 of the hair transplantation layer 4 which formed the detailed member 15 for an ornament, and ] Or a pattern [ that the detailed member 15 for an ornament equipped with the coloring fiber which applied coloring agents, such as a pigment and a color, all over a part of hair transplantation layer 4 was formed ] hair transplantation layer 9 is formed. The adhesive tape 6 for masking whose adhesiveness is completely lost at the time of the temperature rise by heating is made to stick on the upper end-face section 7 of the encaustic hair transplantation layer 9. furthermore, moreover, the manufacturing method The hot melt adhesive of the shape of a slurry which the mold-release characteristic base materials 1, such as paper which performed mold-release characteristic processing, or a synthetic-resin film, were made to distribute the powder of hot melt adhesive, such as a polyethylene system, a polyamide system, and a polyester system, to underwater [ which dissolved the surfactant, the thickener, the defoaming agent, etc. ], and was acquired is applied. The pattern-like sensible-heat type adhesives layer 2 is installed tentatively.

[0008] Next, the pastiness adhesives which have powerful adhesive strength and powerful elasticity, such as a vinyl acetate system, acrylic, and a latex system, are formed in the upper surface of the pattern-like sensible-heat type adhesives layer 2, and the pattern-like glue line 5 is formed.

[0009] Next, before the pattern-like glue line 5 does not carry out dryness hardening, hair is transplanted in the staple fibers 3, such as a rayon nylon system, acrylic, and a polyester system, the hair transplantation layer 4 of a pattern pattern is formed, the solvent of the pattern-like glue line 5 is evaporated, and the pattern-like glue line 5 is made to fix a staple fiber 3.

[0010] Next, the detailed members 15 for an ornament, such as a metal powder, a piece of a foil, a synthetic-resin particle, and colored glass, are formed in the upper part of the hair transplantation layer 4 through adhesives.

[0011] Next, the adhesive tape 6 for masking whose adhesiveness is completely lost at the time of the temperature rise by heating is stuck on the upper end-face section 7 of the hair transplantation layer 4 which formed the detailed member 15 for an ornament of a pattern pattern.

[0012] Or a pattern [ that applied coloring agents, such as a pigment and a color, all over a part of hair

transplantation layer 4 of a pattern pattern, and it had coloring fiber ] hair transplantation layer 9 is formed.

[0013] Next, the detailed members 15 for an ornament, such as a metal powder, a piece of a foil, a synthetic-resin particle, and colored glass, are formed in the upper part of the encaustic hair transplantation layer 9 through adhesives.

[0014] Next, the adhesive tape 6 for masking whose adhesiveness is completely lost at the time of the temperature rise by heating is stuck on the upper end-face section 7 of a pattern [ that the detailed member 15 for an ornament was fixed ] hair transplantation layer 9.

[0015]

[Example] The hot printing formula applique of this invention installs tentatively the pattern-like sensible-heat type adhesives layer 2 hereafter to the mold-release characteristic base materials 1, such as paper which performed mold-release characteristic processing as shown in the drawing, or a synthetic-resin film. The pattern-like glue line 5 which has powerful adhesive strength and powerful elasticity is formed in the upper surface of this pattern-like sensible-heat type adhesives layer 2. Furthermore, carry out hair transplantation fixing of the staple fibers 3, such as cotton, a rayon nylon system, acrylic, and a polyester system, and the hair transplantation layer 4 of a pattern pattern is formed in the pattern-like glue line 5. Adhesives are minded [ of the hair transplantation layer 4 ]. Furthermore, a metal powder, the piece of a foil, a synthetic-resin particle, [ whether the adhesive tape 6 for masking whose adhesiveness forms the detailed members 15 for an ornament, such as colored glass, and is completely further lost at the time of the temperature rise by heating is made to stick on the upper end-face section 7 of the hair transplantation layer 4, and ] Or a pattern [ that it had coloring fiber which applied coloring agents, such as a pigment and a color, all over a part of this hair transplantation layer 4 ] hair transplantation layer 9 is formed. Adhesives are minded [ of the encaustic hair transplantation layer 9 ]. Furthermore, a metal powder, the piece of a foil, a synthetic-resin particle, The adhesive tape 6 for masking whose adhesiveness forms the detailed members 15 for an ornament, such as colored glass, and is completely further lost at the time of the temperature rise by heating is made to stick on the upper end-face section 7 of a pattern [ that the detailed member 15 for an ornament was formed ] hair transplantation layer 9. It is as follows when the 1st example of the manufacturing method is explained per drawing.

[0016] Application tentative installation of the pattern-like sensible-heat type glue line 2 is carried out for the hot melt adhesive of the shape of a slurry which the mold-release characteristic base materials 1, such as paper which performed mold-release characteristic processing as shown in drawing 3 , or a synthetic-resin film, were made to distribute the powder of hot melt adhesive, such as a polyethylene system, a polyamide system, and a polyester system, to underwater [ which dissolved the surfactant, the thickener, the defoaming agent, etc. ], and was acquired at the 1st process with screen-stencil and other meanses.

[0017] The pattern-like glue line 5 is formed by screen-stencil and other meanses with the pastiness adhesives which have powerful adhesive strength and powerful elasticity, such as a vinyl acetate system, acrylic, and a latex system, on the upper surface of the pattern-like sensible-heat type glue line 2 at the 2nd process as shown in drawing 4 .

[0018] As the 3rd process shows to drawing 5 , before the pattern-like glue line 5 does not carry out dryness hardening Colorlessness or the colored staple fiber 3 is sprinkled at length grade of about 0.3mm - 5mm of cotton, a rayon nylon system, acrylic, and a polyester system. It sprays, and hair is transplanted with the means of a swing method, the static electricity method, and others, the hair transplantation layer 4 of a pattern pattern is formed, the solvent of the pattern-like glue line 5 is evaporated, and the pattern-like glue line 5 is made to fix a staple fiber 3.

[0019] As drawing 6 shows at the 4th process, the detailed members 15 for an ornament, such as a metal powder, a piece of a foil, a synthetic-resin particle, and colored glass, are formed in the upper part of the hair transplantation layer 4 through adhesives.

[0020] As drawing 7 shows at the 5th process, at the time of the temperature rise of about 120 degreeC by heating, adhesiveness sticks the completely lost adhesive tape 6 for masking on the upper end-face



section 7 of the hair transplantation layer 4 which formed the detailed member 15 for an ornament of a pattern pattern, and forms the hot printing formula applique 10.

[0021] Moreover, it is as follows when the 2nd example of a manufacturing method is explained per drawing.

[0022] Application tentative installation of the pattern-like sensible-heat type glue line 2 is carried out for the hot melt adhesive of the shape of a slurry which the mold-release characteristic base materials 1, such as paper which performed mold-release characteristic processing as drawing 13 showed, or a synthetic-resin film, were made to distribute the powder of hot melt adhesive, such as a polyethylene system, a polyamide system, and a polyester system, to underwater [ which dissolved the surfactant, the thickener, the defoaming agent, etc. ], and was acquired at the 1st process with screen-stencil and other meanses.

[0023] At the 2nd process, as shown in drawing 14 , the pattern-like glue line 5 is formed in the upper surface of the pattern-like sensible-heat type glue line 2 for the pastiness adhesives which have powerful adhesive strength and powerful elasticity, such as a vinyl acetate system, acrylic, and a latex system, by screen-stencil and other meanses.

[0024] As the 3rd process shows to drawing 15 , before the pattern-like glue line 5 does not carry out dryness hardening, hair is transplanted with the means of spraying, spraying, a swing method, the static electricity method, and others in colorlessness or the colored staple fiber 3 by length grade of about 0.3mm - 5mm of a rayon nylon system, acrylic, and a polyester system, the hair transplantation layer 4 of a pattern pattern is formed, the solvent of the pattern-like glue line 5 is evaporated, and the pattern-like glue line 5 is made to

[0025] A pattern [ that applied coloring agents, such as a pigment and a color, by the means of the screen board 11 or others at the 4th process all over a part of hair transplantation layer 4 of a pattern pattern as drawing 16 showed, and it had coloring fiber ] hair transplantation layer 9 is formed.

[0026] As drawing 17 shows at the 5th process, the detailed members 15 for an ornament, such as a metal powder, a piece of a foil, a synthetic-resin particle, and colored glass, are formed in the upper part of the encaustic hair transplantation layer 9 through adhesives.

[0027] The adhesive tape 6 for masking whose adhesiveness is completely lost at the time of the temperature rise of about 120 degreeC by heating as drawing 18 shows at the 6th process is stuck on the upper end-face section 7 of a pattern [ that the detailed member 15 for an ornament was formed ] hair transplantation layer 9.

[0028] moreover, transferred [ on which 12 looks a transferred member like / transferred / , an encaustic handle and 14 look 13 like / transferred / , and the pattern-like sensible-heat type adhesives layer 2 is pasted up ] -- it is the processed field of a member 12

[0029] 8 [ moreover, ] -- transferred -- the after [ an imprint ] pattern-like sensible-heat type glue line 5 to a member 12 -- transferred -- it is the glue-line section which showed the portion which carried out osmosis adhesion and became thin at the member 12

[0030]

[Function and Effect of the Invention] The pattern-like sensible-heat type adhesives layer 2 is installed tentatively to the mold-release characteristic base materials 1, such as paper which this invention is the above composition and performed mold-release characteristic processing, or a synthetic-resin film. The pattern-like glue line 5 which has powerful adhesive strength and powerful elasticity is formed in the upper surface of this pattern-like sensible-heat type adhesives layer 2. Furthermore, the staple fibers 3, such as a rayon nylon system, acrylic, and a polyester system, are formed in the pattern-like glue line 5. Adhesives are minded [ of the hair transplantation layer 4 ]. Furthermore, a metal powder, the piece of a foil, a synthetic-resin particle, The detailed members 15 for an ornament, such as colored glass, are formed. Moreover, when adhesiveness made the completely lost adhesive tape 6 for masking stick on the upper end-face section 7 of the hair transplantation layer 4 which formed the detailed member 15 for an ornament of a pattern pattern and formed the hot printing formula applique 10 further at the time of the temperature rise by heating It exfoliates from the pattern-like sensible-heat type adhesives layer 2. transferred -- at the time of the imprint to a member 12, as the mold-release characteristic base material

1 was illustrated to drawing 8 and drawing 19 It flows into the organization of a member 12. next, the pattern-like sensible-heat type adhesives layer 2 -- transferred -- the hot melt adhesive which dissolved when heated at the temperature (about 120degreeC) which the hot melt adhesive which hit against the processed field 14 of a member 12, and was contained in the pattern-like sensible-heat type adhesives layer 2 with heaters, such as an iron, dissolves -- transferred -- On the other hand, the adhesive tape 6 for masking can carry out ablation removal of the adhesive tape 6 for masking easily, as it illustrated to drawing 10 and drawing 21 , since adhesiveness was completely lost in the time of the temperature rise by heating (about 120degreeC). While cooling after that, the hot melt adhesive which flowed will be in an adhesion state firmly.

[0031] therefore, transferred -- a pattern that the beautiful detailed member 15 for an ornament was formed in the member 12 is formed

[0032] Moreover, a pattern [ that it had irregularity ] handle 13 can be acquired by differing in the length of the staple fiber 3 which forms the hair transplantation layer 4.

[0033] Moreover, coloring agents, such as a pigment and a color, can be applied all over a part of hair transplantation layer 4 of a pattern pattern, it can have coloring fiber, and a desired pattern can be performed simply and quickly certainly by having formed a pattern [ that the detailed member 15 for an ornament was formed further ] hair transplantation layer 9.

[0034] By the mold-release characteristic base material 1, the hair transplantation layer 4 is pinched, the hair transplantation layer 4 which does not continue and deteriorate at a long period of time can be obtained at the time of storage, and it can form the beautiful encaustic handle 13 again at the time of an imprint while sticking the adhesive tape 6 for masking whose adhesiveness is completely lost at the time of the temperature rise by heating on the upper end-face section 7 which formed the detailed member 15 for an ornament of the hair transplantation layer 4 or the encaustic hair transplantation layer 9.

[0035] furthermore, the imprint to a transferred member which has elasticity -- being easy -- transferred -- on the occasion of expansion and contraction of a member, the crevice between staple fibers 3 is suitably adjusted by the pattern-like glue line 5, defluxion of a staple fiber 3 is prevented, and encaustic handles, such as a three-dimensional and beautiful pattern or a character, can be acquired

[0036] Moreover, by having considered as the bilayer of the pattern-like sensible-heat type adhesives layer 2 and the pattern-like glue line 5, adhesion to a transferred member and defluxion of the hair transplantation layer 4 are ensured, it continues and the encaustic handle 13 after an imprint can be saved at a long period of time.

[0037] Moreover, conventionally, although removal cleaning of the excessive powder or excessive pellet-like hot melt adhesive for being sprinkled by hair transplantation portions other than the pattern pattern which powder or pellet-like hot melt adhesive needs in a processing process must be carried out, it is not necessary to perform a complicated means like the conventional process on the occasion of formation of the pattern-like sensible-heat type glue line 5, and the pattern-like sensible-heat type glue line 5 is formed at an easy process.

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## EXAMPLE

[Example] The hot printing formula applique of this invention installs tentatively the pattern-like sensible-heat type adhesives layer 2 hereafter to the mold-release characteristic base materials 1, such as paper which performed mold-release characteristic processing as shown in the drawing, or a synthetic-resin film. The pattern-like glue line 5 which has powerful adhesive strength and powerful elasticity is formed in the upper surface of this pattern-like sensible-heat type adhesives layer 2. Furthermore, carry out hair transplantation fixing of the staple fibers 3, such as cotton, a rayon nylon system, acrylic, and a polyester system, and the hair transplantation layer 4 of a pattern pattern is formed in the pattern-like glue line 5. Adhesives are minded [ of the hair transplantation layer 4 ]. Furthermore, a metal powder, the piece of a foil, a synthetic-resin particle, [ whether the adhesive tape 6 for masking whose adhesiveness forms the detailed members 15 for an ornament, such as colored glass, and is completely further lost at the time of the temperature rise by heating is made to stick on the upper end-face section 7 of the hair transplantation layer 4, and ] Or a pattern [ that it had coloring fiber which applied coloring agents, such as a pigment and a color, all over a part of this hair transplantation layer 4 ] hair transplantation layer 9 is formed. Adhesives are minded [ of the encaustic hair transplantation layer 9 ]. Furthermore, a metal powder, the piece of a foil, a synthetic-resin particle, The adhesive tape 6 for masking whose adhesiveness forms the detailed members 15 for an ornament, such as colored glass, and is completely further lost at the time of the temperature rise by heating is made to stick on the upper end-face section 7 of a pattern [ that the detailed member 15 for an ornament was formed ] hair transplantation layer 9. It is as follows when the 1st example of the manufacturing method is explained per drawing.

[0016] Application tentative installation of the pattern-like sensible-heat type glue line 2 is carried out for the hot melt adhesive of the shape of a slurry which the mold-release characteristic base materials 1, such as paper which performed mold-release characteristic processing as shown in drawing 3 , or a synthetic-resin film, were made to distribute the powder of hot melt adhesive, such as a polyethylene system, a polyamide system, and a polyester system, to underwater [ which dissolved the surfactant, the thickener, the defoaming agent, etc. ], and was acquired at the 1st process with screen-stencil and other meanses.

[0017] The pattern-like glue line 5 is formed by screen-stencil and other meanses with the pastiness adhesives which have powerful adhesive strength and powerful elasticity, such as a vinyl acetate system, acrylic, and a latex system, on the upper surface of the pattern-like sensible-heat type glue line 2 at the 2nd process as shown in drawing 4 .

[0018] As the 3rd process shows to drawing 5 , before the pattern-like glue line 5 does not carry out dryness hardening Colorlessness or the colored staple fiber 3 is sprinkled at length grade of about 0.3mm - 5mm of cotton, a rayon nylon system, acrylic, and a polyester system. It sprays, and hair is transplanted with the means of a swing method, the static electricity method, and others, the hair transplantation layer 4 of a pattern pattern is formed, the solvent of the pattern-like glue line 5 is evaporated, and the pattern-like glue line 5 is made to fix a staple fiber 3.

[0019] As drawing 6 shows at the 4th process, the detailed members 15 for an ornament, such as a metal

powder, a piece of a foil, a synthetic-resin particle, and colored glass, are formed in the upper part of the hair transplantation layer 4 through adhesives.

[0020] As drawing 7 shows at the 5th process, at the time of the temperature rise of about 120 degreeC by heating, adhesiveness sticks the completely lost adhesive tape 6 for masking on the upper end-face section 7 of the hair transplantation layer 4 which formed the detailed member 15 for an ornament of a pattern pattern, and forms the hot printing formula applique 10.

[0021] Moreover, it is as follows when the 2nd example of a manufacturing method is explained per drawing.

[0022] Application tentative installation of the pattern-like sensible-heat type glue line 2 is carried out for the hot melt adhesive of the shape of a slurry which the mold-release characteristic base materials 1, such as paper which performed mold-release characteristic processing as drawing 13 showed, or a synthetic-resin film, were made to distribute the powder of hot melt adhesive, such as a polyethylene system, a polyamide system, and a polyester system, to underwater [ which dissolved the surfactant, the thickener, the defoaming agent, etc. ], and was acquired at the 1st process with screen-stencil and other meanses.

[0023] At the 2nd process, as shown in drawing 14 , the pattern-like glue line 5 is formed in the upper surface of the pattern-like sensible-heat type glue line 2 for the pastiness adhesives which have powerful adhesive strength and powerful elasticity, such as a vinyl acetate system, acrylic, and a latex system, by screen-stencil and other meanses.

[0024] As the 3rd process shows to drawing 15 , before the pattern-like glue line 5 does not carry out dryness hardening, hair is transplanted with the means of spraying, spraying, a swing method, the static electricity method, and others in colorlessness or the colored staple fiber 3 by length grade of about 0.3mm - 5mm of a rayon nylon system, acrylic, and a polyester system, the hair transplantation layer 4 of a pattern pattern is formed, the solvent of the pattern-like glue line 5 is evaporated, and the pattern-like glue line 5 is made to

[0025] A pattern [ that applied coloring agents, such as a pigment and a color, by the means of the screen board 11 or others at the 4th process all over a part of hair transplantation layer 4 of a pattern pattern as drawing 16 showed, and it had coloring fiber ] hair transplantation layer 9 is formed.

[0026] As drawing 17 shows at the 5th process, the detailed members 15 for an ornament, such as a metal powder, a piece of a foil, a synthetic-resin particle, and colored glass, are formed in the upper part of the encaustic hair transplantation layer 9 through adhesives.

[0027] The adhesive tape 6 for masking whose adhesiveness is completely lost at the time of the temperature rise of about 120 degreeC by heating as drawing 18 shows at the 6th process is stuck on the upper end-face section 7 of a pattern [ that the detailed member 15 for an ornament was formed ] hair transplantation layer 9.

[0028] moreover, transferred [ on which 12 looks a transferred member like / transferred /, an encaustic handle and 14 look 13 like / transferred /, and the pattern-like sensible-heat type adhesives layer 2 is pasted up ] -- it is the processed field of a member 12

[0029] 8 [ moreover, ] -- transferred -- the after [ an imprint ] pattern-like sensible-heat type glue line 5 to a member 12 -- transferred -- it is the glue-line section which showed the portion which carried out osmosis adhesion and became thin at the member 12

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[Translation done.]

\* NOTICES \*

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1. This document has been translated by computer. So the translation may not reflect the original precisely.
2. \*\*\*\* shows the word which can not be translated.
3. In the drawings, any words are not translated.

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TECHNICAL FIELD

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[Industrial Application] this invention -- manufacture -- while it is easy, it is related with the hot printing formula applique which can ensure an imprint to a desired position, and its manufacturing method

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[Translation done.]